

Work Order ID 62055

Wednesday, September 15, 2010 1:28:51 PM



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Item ID: D119-755-014

Accept



Setup Start



Revision ID:

Stop



Item Name: Bubble Window, RH

Start Date: 9/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-9-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

U/R

Rev U/R

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP 119-755-014 CHG 001

8/10/10/01

HJ for BG 10-9-29

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

CU 10/9/29 CU

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/10/01

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62055

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Item ID: D119-755-014

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Item Name: Bubble Window, RH

Start Date: 9/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-755-014 Location: _____ PPP Rev: <u>A</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Handwritten signature and date: 9/15/10

Handwritten date: 10/10/05

Handwritten date: 10-10-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 62055

Parent Item: D119-755-014

Parent Item Name: Bubble Window, RH




Start Date: 9/15/2010

Required Date: 9/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A New Issue 6/28/2007 DL
IPP B Dwg. Update 4/25/2008 DL verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3624-2 		Manufactured	No			110	Each	0.0000	1	1			
Bubble Window										68056			
D2126 		Manufactured	No			110	f	316.2234	8.5	8.947368			
Seal													
<div> <div>71 @ 85" long</div> <div>↳ messes</div> <div>8109129</div> </div>													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST405	316.2234211						
						48285	22.0884211						
						57106	294.135						
D3561-1 		Manufactured	No			110	Each	5.0000	1	1			
Seal Insert Tool										57106			
										62409			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST070	5						
						56109	5						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

3.2 Installation of D119-755-014 Bubble Window Kit

The Dart D119-755-014 Bubble Window Kit installs in the RH crew door of the A119/AW119MKII aircraft and should be installed as follows:

- 3.2.1 Remove RH crew door (109-0360-01-164 or equivalent) from the aircraft per the Aircraft Maintenance Manual.
- 3.2.2 Remove the existing window per the Aircraft Maintenance Manual or applicable instructions.
- 3.2.3 Install the D3624-2 Bubble Window in the doorframe using D2126-0850 Seal as shown in Figure 1. Before actually installing the window, verify that there is at least 0.30" (7.6mm) of overlap between the window and the door frame along the straight edges of the window and at least 0.12" (3.0mm) of overlap along the radius of the corners. The recommended procedure is to install the seal onto the door and then to install the window into the seal. Trim the ends of the seal as required. Seal ends should meet at the 6 o'clock position with a maximum gap of 0.125" (3.2mm). If a gap exists, it should be filled with Proseal or PRC. The included D3561-1 Seal Insert Tool can be used to assist in working the seal around the window. If necessary, it is acceptable to trim the window to improve the fit as long as the minimum overlap values are maintained.
- 3.2.4 Reinstall modified crew door on the aircraft per the Aircraft Maintenance Manual. Verify proper closing and sealing of the door.
- 3.2.5 Note: To increase downward viewing clarity, it is acceptable to cut a small section from the bubble window on its downward side. The cut-out can be a maximum of 5.25" wide x 13.50" long (133mm x 343mm), measured along the profile of the bubble window. The corners of the cut-out must have a minimum radius of 2" (50mm). The cut-out should be located within 1.0" to 1.5" (25mm to 38mm) of the bubble flange. The actual shape of the cutout can vary as desired, as long as the overall dimensions are within the specified limits. See Figure 2 for reference.

4.0 WEIGHT AND BALANCE

The following are the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-755-011	3.5 lb	±27.6 in	±97 in-lb	63 in	220 in-lb
Crew Door Window Kit, LH / RH	1.6 kg	±0.70 m	±1.12 m-kg	1.60 m	2.6 m-kg
D119-755-014	4.5 lb	+31.6 in	+142 in-lb	63 in	284 in-lb
Bubble Window Kit, RH	2.0 kg	+0.80 m	+1.60 m-kg	1.60 m	2.6 m-kg

5.0 PARTS LIST

Qty -011	Qty -014	Part Number	Description
X		D119-755-011	CREW DOOR WINDOW KIT (FITS LH & RH)
	X	D119-755-014	BUBBLE WINDOW KIT, RH
1	1	D2126-0850	SEAL
1		D3623-1	WINDOW
	1	D3624-2	BUBBLE WINDOW
1	1	*D3561-1	SEAL INSERT TOOL

* Not part of the -011/-014 installations, tool only